

Work Order ID 52758

October 14, 2009 9:06:12 AM



Page 1

Item ID:	D3953-7	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	Gas Spring Spacer					
Start Date:	14/10/2009	Start Qty:	12.00	Cust Item ID:		
Required Date:	21/10/2009	Req'd Qty:	12.00	Customer:		

Reference:				Run	Start	
Approvals:	Process Plan:	Date: <u>27-10-14</u>	Tooling:		Date:	
	QC:	Date:	SPC (Y/N):		Date:	
					Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3953	A

100	0.00		09/10/15	20	
	0.00				

Hardinge

Hardinge CNC Lathe Small

Memo

TURN AS PER FOLIO FA854 & DWG

FOLIO REV: N/A

DWG REV: A

DEBURR

110	0.00		09/10/15	20	
	0.00				

QC

Quality Control

Memo

QC2- Inspect parts off machine FAI/FAIB

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Page 2

Item ID: D3953-7 Accept Setup Start
Revision ID: A Stop
Item Name: Gas Spring Spacer
Start Date: 14/10/2009 Start Qty: 12.00 Cust Item ID:
Required Date: 21/10/2009 Req'd Qty: 12.00 Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				20			
130 Packaging Packaging	Identify as per dwg & Stock Location: BAC Memo	0.00 0.00							
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

09/10/19
mf
09-10-19

Picklist Print

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Page 1

Work Order ID: 52758



Parent Item: D3953-7



Parent Item Name: Gas Spring Spacer

Start Date: 14/10/2009

Required Date: 21/10/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MDELNR0.750		Purchased	No			100	f	95.0275	0.6316			

Delrin Round Bar 0.75"

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	95.0275	
109183	1.84	
110962	12.26	
112418	65.0275	
112480	15.9	

82 AT SACR10/15

32~

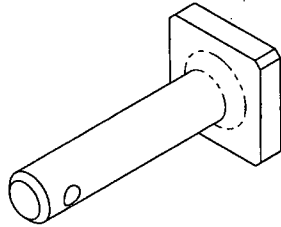
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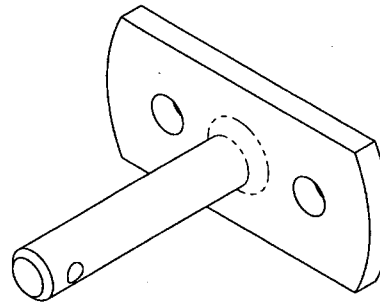
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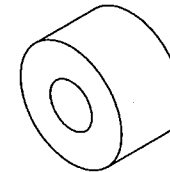
D3953-1 GAS SPRING BRACKET
(FULL LID)



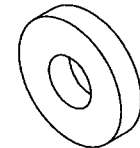
D3953-3 GAS SPRING STUD, LID



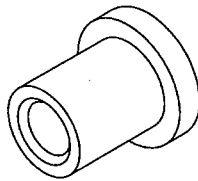
D3953-5 GAS SPRING STUD, BASE



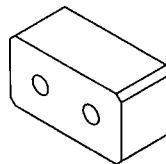
D3953-7 GAS SPRING SPACER



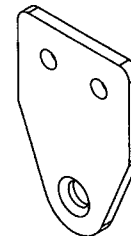
D3953-9 GAS SPRING WASHER



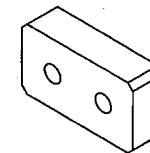
D3953-11 GAS SPRING SPACER



D3953-13 GAS SPRING SPACER
(FULL LID)



D3953-15 GAS SPRING BRACKET
(SPLIT LID)



D3953-17 GAS SPRING SPACER
(SPLIT LID)

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2009-10-08

A		NEW ISSUE		AJS	09.07.27
REV.	DESCRIPTION			BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			REV. A
DRAWN	AJS				
CHECKED	AJS	DRAWING NO.	SHEET 1 OF 4		
MFG. APPR.	AJS	D3953			
APPROVED	AJS	TITLE	SCALE		
DE APPR.	AJS	GAS SPRING LID COMPONENTS	NTS		
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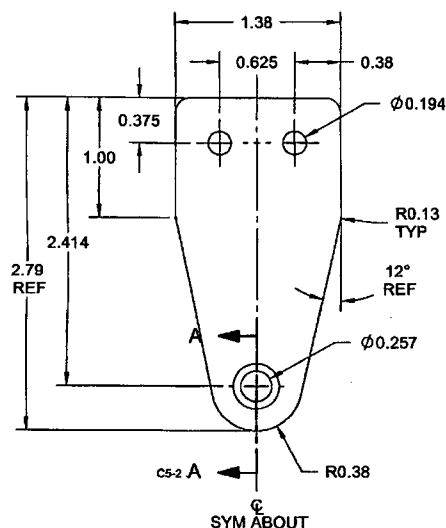
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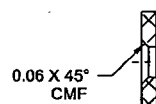
WORK ORDER NO.

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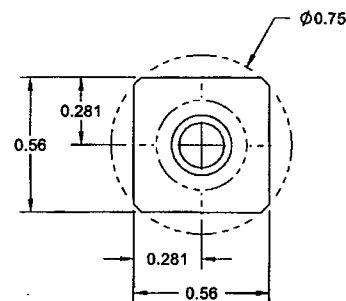
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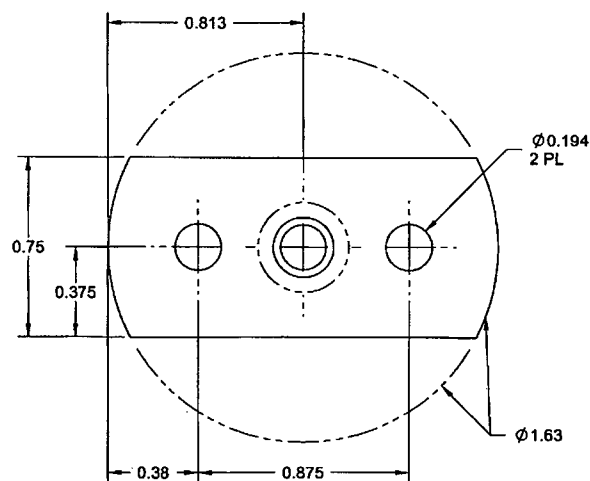
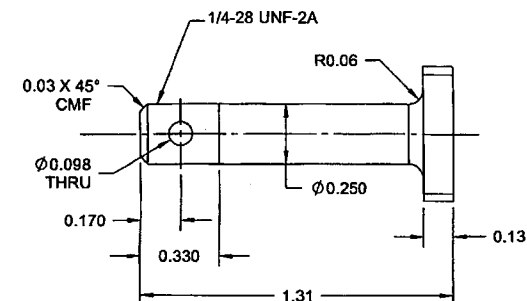
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(FULL LID)



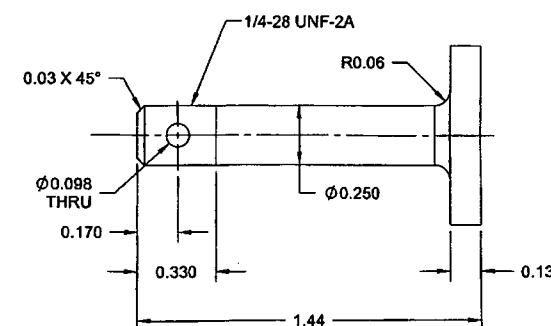
SECTION A-A C7-2



D3953-3 GAS SPRING STUD, LID



D3953-5 GAS SPRING STUD, BASE



NOTES:

1) MATERIAL -1: MATERIAL: AISI 304 STAINLESS STEEL SHEET, 0.125 THICK
REF DART SPEC M304S

-3 & -5: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

OR: AISI 304/316 STAINLESS STEEL ROD
REF DART SPEC M304R

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -1: 0.11 lbs

-3: 0.03 lbs

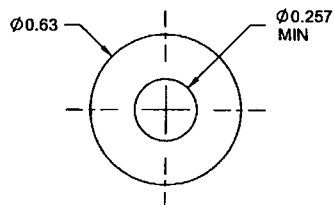
-5: 0.06 lbs

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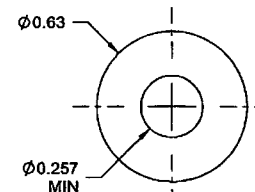
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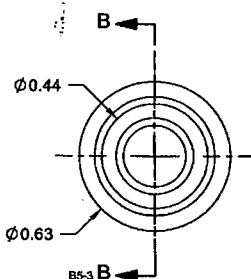
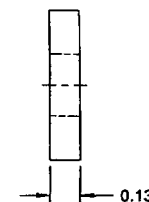
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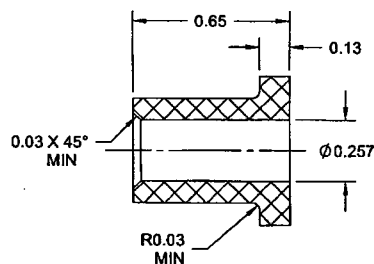
D3953-7 GAS SPRING SPACER



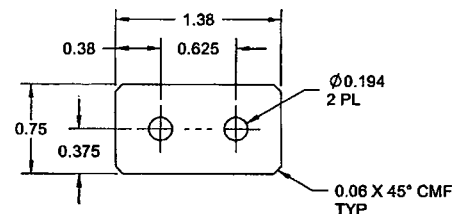
D3953-9 GAS SPRING WASHER



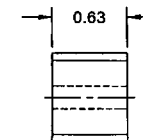
D3953-11 GAS SPRING SPACER



SECTION B-B B7-3



D3953-13 GAS SPRING SPACER



NOTES:

1) MATERIAL -7,-9 & -11: DELRIN II 150E OR ACETRON GP ACETAL, BLACK
REF DART SPEC M-DELRIN-R

-13: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION -13 ONLY: IDENTIFY WITH DART P/N "D3953-13" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -7/-9/-11: < 0.01 lbs EACH

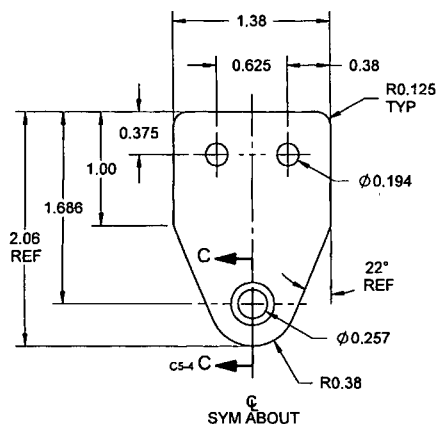
-13: 0.17 lbs

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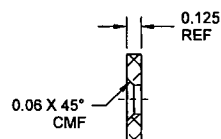
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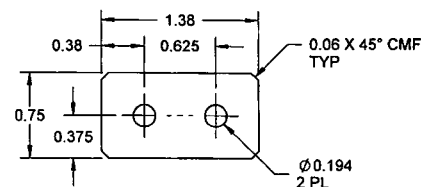
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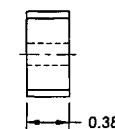
D3953-15 GAS SPRING BRACKET
(SPLIT LID)



SECTION C-C C7-4



D3953-17 GAS SPRING SPACER
(SPLIT LID)



NOTES:

1) MATERIAL -15: MATERIAL: AISI 304 STAINLESS STEEL SHEET, 0.125 THICK
REF DART SPEC M304S

-17: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

- 2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT -15: 0.08 lbs
-17: 0.10 lbs

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